

Work Order ID 127624

127624

Page 1

December-17-14 1:40:54 PM

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Inboard RH
 Start Date: 12/11/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 14-12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3884	B								

100 0.00
100 HAAS CNC VERTICAL MACHINING #1 8 0 JFL 2015-04-23
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Program Batch No. 3127624
 Double check by: B
 1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB 8 0 JFL 2015-04-23
 QC Memo 0.00
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127624

127624

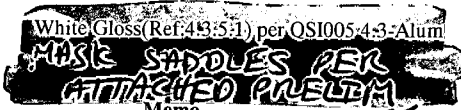
Page 2

December-17-14 1:40:54 PM

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Inboard RH
 Start Date: 12/11/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120 QC Quality Control	Memo	0.00				8	0		
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130 HandFinish Hand Finishing	Memo	0.00				8	0	15-5-15	<i>[Signature]</i>
140	White Gloss (Ref: 43351) per QSI005 4.3 Alum	0.00							
140 Powdercoat Powder Coating	Memo START TIME: 1:55 OVEN TEMPERATURE: 200° FINISH TIME: 2:25	0.00				8	0	15-5-19	<i>[Signature]</i>



M131345

DQA:

Date: 15/06/05



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/06/01

Work Order update only ☐

Work Order: <u>127624</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3884-2</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☒
NCR No. <u>15-5041</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15.05.05	NO	4	NO FINISH ON SADDLE CONCAVE SURFACES	A.P. 15.05.15	ACCEPTABLE (Aldine only) PER ATTACHED PRELIM DWG	DAS 34 9-89	DAS 38 9-89	DAS 9 9-89
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☒ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☒ Other	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled
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127624

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Saddle, Inboard RH

Start Date: 12/11/14 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 12/17/14 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC3- Inspect Part Finish

0.00

150

QC	Memo	0.00
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Quality Control

DAS
38

9-89
MAY 20 2015

160	Identify as per dwg & Stock Location:	0.00
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160

Packaging	Memo	0.00
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Packaging

8

MAY 21 2015

170	QC21- Final Inspection - Work Order Release	0.00
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170

QC	Memo	0.00
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Quality Control

MLJ MAY 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:40:54 PM

Page 1

Work Order ID: 127624

127624

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inboard RH

Start Date: 12/11/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017		Manufactured	No				Each	10.0000		4			
D6101-017									**				
Saddle Billet													

Location

MAT040

124346

129 915

Loc Qty

10

10

150422

Loc Code

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order:	127624
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.641	0.643	0.645	0.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.612	0.618	0.619	0.618		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.003	2.003	2.003	2.004		
J	0.140	0.175		0.154	0.151	0.150	0.149		
K	1.265	1.285		1.268	1.268	1.268	1.269		
L	0.115	0.135		0.126	0.126	0.126	0.126		
M	0.240	0.260		0.251	0.251	0.250	0.251		
N	0.110	0.140		0.138	0.138	0.138	0.138		
O	0.240	0.260		0.253	0.251	0.252	0.252		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.160	0.155	0.155	0.155		
S	0.720	0.780		0.767	0.767	0.767	0.767		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.499	0.498	0.499	0.500		
Y	0.020	0.040		0.030	0.030	0.030	0.030		
Z	0.313	0.318		0.314	0.314	0.314	0.314		
AA	0.760	0.765		0.760	0.760	0.760	0.760		
AB	0.215	0.220		0.219	0.219	0.219	0.219		
AC	0.316	0.321		0.317	0.317	0.317	0.317		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.002	1.005	1.000	1.002		
AF									
Accept/Reject									

Measured by:	JFL
Date:	2015-04-23

Audited by:	H.C.
Date:	15/04/30

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	127624
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.648	0.647	0.648	0.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.618	0.619	0.619	0.619		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.003	2.003	2.003	2.003		
J	0.140	0.175		0.150	0.150	0.151	0.148		
K	1.265	1.285		1.268	1.268	1.268	1.268		
L	0.115	0.135		0.125	0.126	0.126	0.126		
M	0.240	0.260		0.250	0.250	0.250	0.250		
N	0.110	0.140		0.138	0.138	0.138	0.138		
O	0.240	0.260		0.253	0.252	0.252	0.251		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.155	0.155	0.156	0.155		
S	0.720	0.780		0.767	0.767	0.767	0.767		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.499	0.500	0.499	0.499		
Y	0.020	0.040		0.030	0.030	0.030	0.030		
Z	0.313	0.318		0.314	0.314	0.314	0.314		
AA	0.760	0.765		0.760	0.760	0.760	0.760		
AB	0.215	0.220		0.219	0.219	0.219	0.219		
AC	0.316	0.321		0.317	0.317	0.317	0.317		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.001	1.002	1.001		
AF									
Accept/Reject									

Measured by:	JFL
Date:	2015-04-24

Audited by:	J.A
Date:	15/04/30

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

DQA: _____ Date: _____

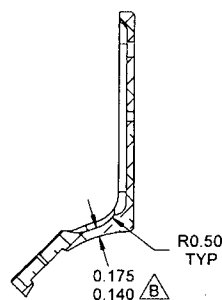


WORK ORDER NON-CONFORMANCE / UPDATE

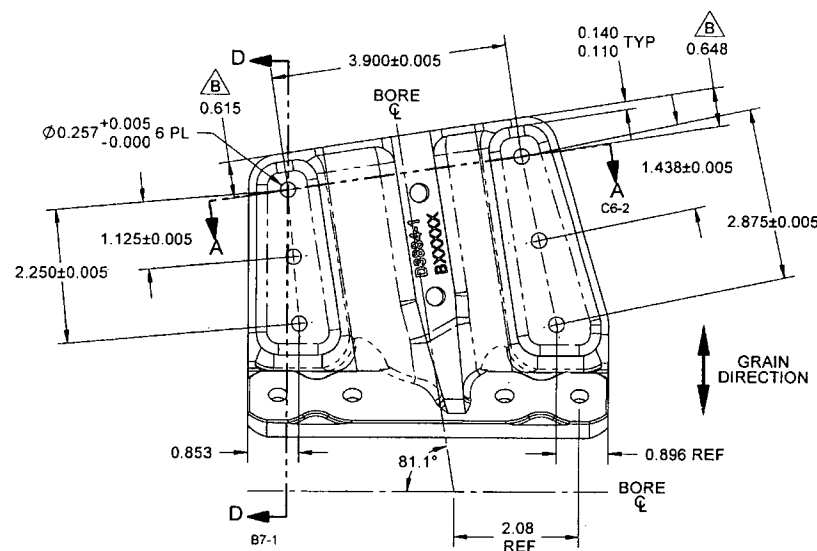
QA Closed: _____ Date: _____

Work Order update only ☐

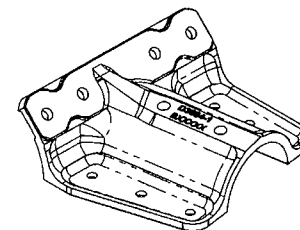
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



SECTION D-D B6-1

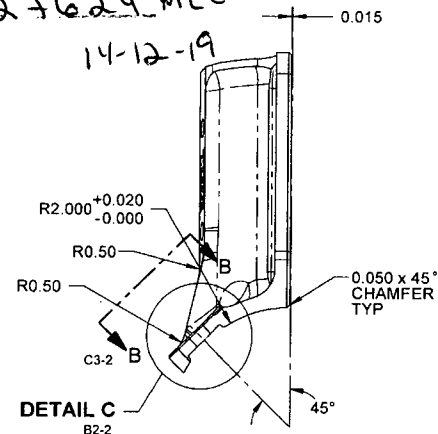


D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)



LAST COPY
RETURN TO
CONTROLLED COPY
NOT TO BE REPRODUCED
WITHOUT NOTICE
ORDER

127624 ML5
14-12-19

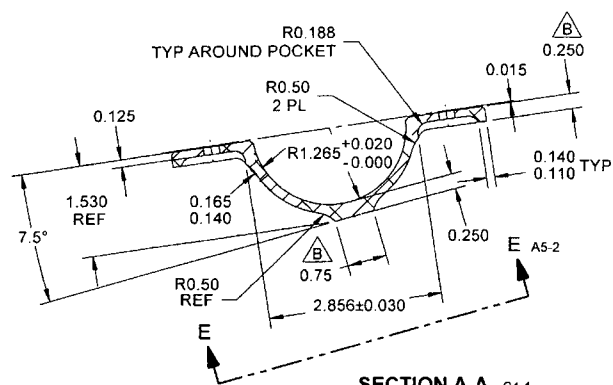


RELEASED
07/15/14

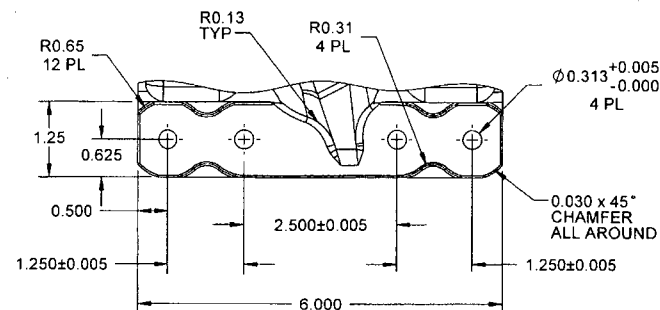
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

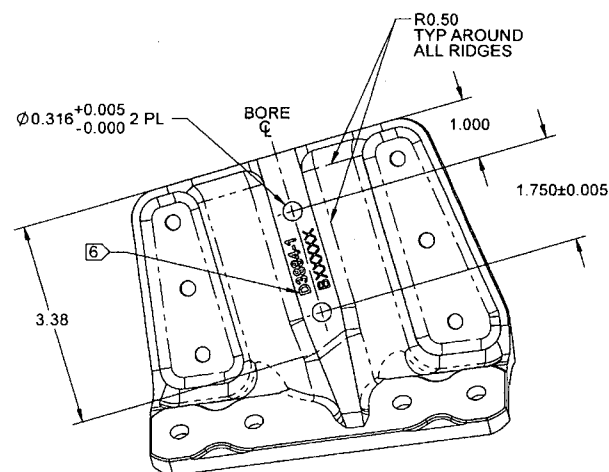
B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.615. ZN C6-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.060. ZN C2-2; 0.75 WAS 0.65. ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



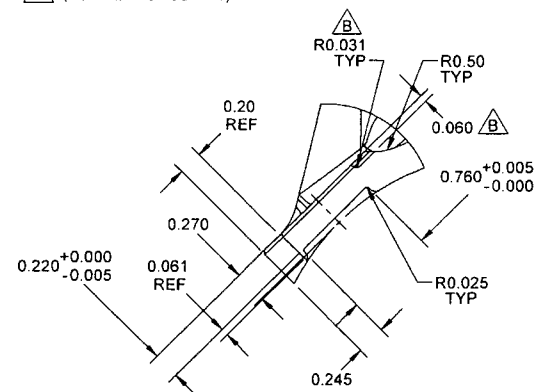
SECTION A-A C4-1



VIEW B-B B3-1
(ROTATED FOR CLARITY)



VIEW E-E C6-2



DETAIL C B3-1
SCALE 2X

RELEASED
09/15/10

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
DATE	09.06.30	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Part Number: D3884-2	Rev: B	- Page 1 -
Description: INBOARD SADDLE	Inspection Dwg: D3884	Work Order: 127624

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
A	2.875	0.005 -0.005	2.875	2.875	2.876	2.876	
B	1.438	0.005 -0.005	1.437	1.438	1.438	1.438	
C	0.648	0.010 -0.010	0.648	0.651	0.652	0.654	
D	3.900	0.005 -0.005	3.898	3.898	3.899	3.899	
E	0.2570	0.0050 -0.0010	0.2574	0.2572	0.2579	0.2576	
F	0.615	0.010 -0.010	0.617	0.622	0.622	0.622	
G	1.125	0.005 -0.005	1.126	1.125	1.125	1.126	
H	2.250	0.005 -0.005	2.251	2.251	2.250	2.251	
I	2.000	0.020 0.000	2.003	2.003	2.004	2.004	
J	0.140	0.035 0.000	0.154	0.151	0.150	0.149	
K	1.265	0.020 0.000	1.268	1.269	1.269	1.269	
L	0.125	0.010 -0.010	0.126	0.126	0.126	0.127	
M	0.250	0.010 -0.010	0.251	0.250	0.250	0.252	
N	0.125	0.015 -0.015	0.138	0.138	0.138	0.138	
O	0.250	0.010 -0.010	0.253	0.251	0.252	0.252	
P	2.856	0.030 -0.030	2.856	2.856	2.856	2.856	
Q	0.188	0.010 -0.010	0.192	0.193	0.193	0.193	

Measured by:
Mathieu Lamarche

Date:
2015-5-10

Audited by:

Date:



Part Number: D3884-2	Rev: B	- Page 2 -
Description: INBOARD SADDLE	Inspection Dwg: D3884	Work Order: 127624

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
R	0.140	0.025 0.000	0.160	0.155	0.155	0.155	
S	0.750	0.030 -0.030	0.767	0.767	0.767	0.767	
T	1.250	0.030 -0.030	1.250	1.250	1.250	1.250	
U	1.250	0.005 -0.005	1.249	1.250	1.250	1.249	
V	6.000	0.010 -0.010	6.001	6.002	6.002	6.002	
W	2.500	0.005 -0.005	2.500	2.499	2.499	2.500	
X	0.500	0.010 -0.010	0.501	0.500	0.500	0.501	
Y	0.030	0.010 -0.010	0.030	0.030	0.030	0.030	
Z	0.3130	0.0050 -0.0010	0.3130	0.3128	0.3130	0.3129	
AA	0.760	0.005 0.000	0.760	0.760	0.760	0.760	
AB	0.220	0.000 -0.005	0.219	0.219	0.219	0.219	
AC	0.3160	0.0050 -0.0010	0.3151	0.3151	0.3150	0.3150	
AD	1.750	0.005 -0.005	1.750	1.750	1.750	1.749	
AE	1.000	0.010 -0.010	1.001	1.004	1.001	1.001	

Measured by:
Mathieu Lamarche

Date:
2015-5-10

Audited by:

Date:



Part Number: D3884-2	Rev: B	- Page 1 -
Description: INBOARD SADDLE	Inspection Dwg: D3884	Work Order: 127624

Name	Nominal	Upper Tol Lower Tol	No. Piece_5 Actual	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	
A	2.875	0.005 -0.005	2.876	2.876	2.876	2.876	
B	1.438	0.005 -0.005	1.438	1.438	1.439	1.438	
C	0.648	0.010 -0.010	0.654	0.654	0.655	0.653	
D	3.900	0.005 -0.005	3.899	3.899	3.899	3.900	
E	0.2570	0.0050 -0.0010	0.2579	0.2572	0.2577	0.2574	
F	0.615	0.010 -0.010	0.623	0.623	0.623	0.623	
G	1.125	0.005 -0.005	1.126	1.125	1.125	1.125	
H	2.250	0.005 -0.005	2.251	2.250	2.250	2.250	
I	2.000	0.020 0.000	2.003	2.003	2.004	2.003	
J	0.140	0.035 0.000	0.150	0.150	0.151	0.148	
K	1.265	0.020 0.000	1.268	1.268	1.269	1.269	
L	0.125	0.010 -0.010	0.127	0.126	0.126	0.127	
M	0.250	0.010 -0.010	0.252	0.251	0.251	0.252	
N	0.125	0.015 -0.015	0.138	0.138	0.138	0.138	
O	0.250	0.010 -0.010	0.253	0.252	0.252	0.251	
P	2.856	0.030 -0.030	2.856	2.856	2.856	2.856	
Q	0.188	0.010 -0.010	0.193	0.192	0.192	0.191	

Measured by:
Mathieu Lamarche

Date:
2015-5-10

Audited by:

Date:



Part Number: D3884-2	Rev: B	- Page 2 -
Description: INBOARD SADDLE	Inspection Dwg: D3884	Work Order: 127624

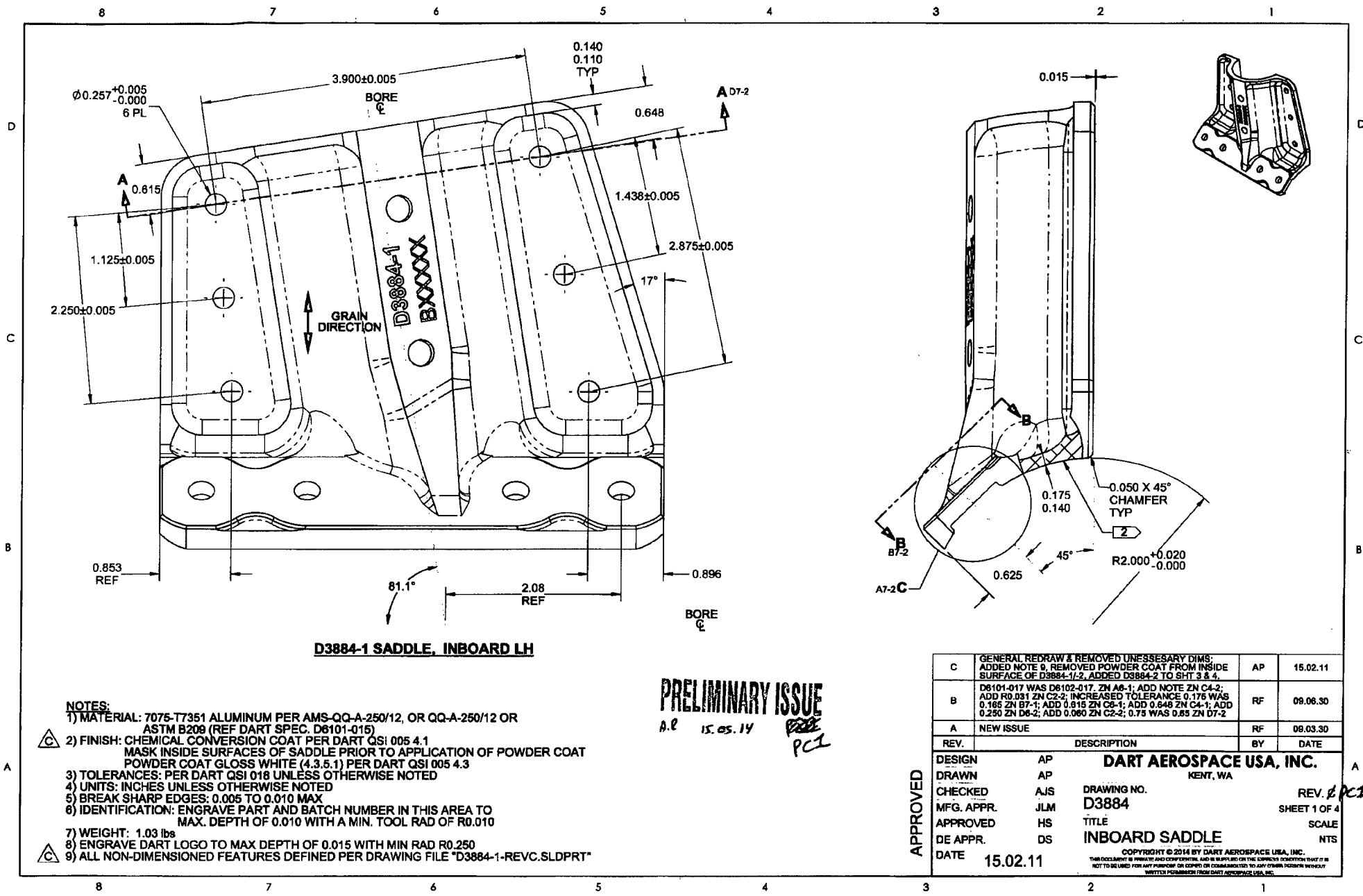
Name	Nominal	Upper Tol Lower Tol	No. Piece_5 Actual	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	
R	0.140	0.025 0.000	0.155	0.155	0.156	0.155	
S	0.750	0.030 -0.030	0.767	0.767	0.767	0.767	
T	1.250	0.030 -0.030	1.250	1.250	1.250	1.250	
U	1.250	0.005 -0.005	1.250	1.249	1.249	1.250	
V	6.000	0.010 -0.010	6.002	6.002	6.002	6.001	
W	2.500	0.005 -0.005	2.500	2.500	2.499	2.500	
X	0.500	0.010 -0.010	0.500	0.501	0.502	0.500	
Y	0.030	0.010 -0.010	0.030	0.030	0.030	0.030	
Z	0.3130	0.0050 -0.0010	0.3127	0.3130	0.3129	0.3132	
AA	0.760	0.005 0.000	0.760	0.760	0.760	0.760	
AB	0.220	0.000 -0.005	0.219	0.219	0.219	0.219	
AC	0.3160	0.0050 -0.0010	0.3151	0.3152	0.3154	0.3154	
AD	1.750	0.005 -0.005	1.750	1.750	1.751	1.749	
AE	1.000	0.010 -0.010	1.001	1.001	1.001	1.001	

Measured by:
Mathieu Lamarche

Date:
2015-5-10

Audited by:

Date:



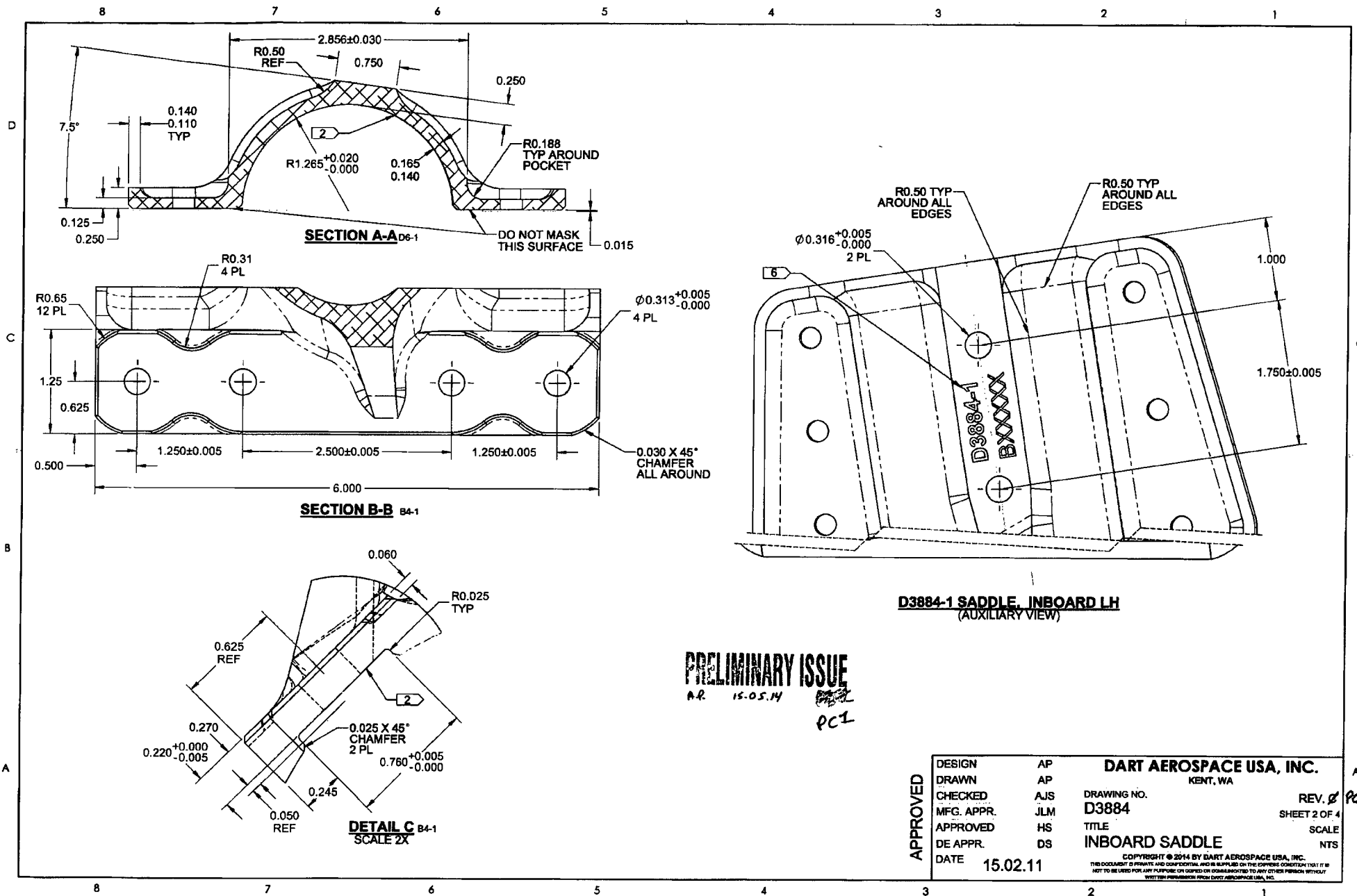
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B208 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-1-REVC.SLDPRJT"

PRELIMINARY ISSUE
A.E 15.05.14
PC1

C	GENERAL REDRAW & REMOVED UNNECESSARY DIMS; ADDED NOTE 9, REMOVED POWDER COAT FROM INSIDE SURFACE OF D3884-1/2, ADDED D3884-2 TO SHT 3 & 4.	AP	15.02.11
B	D6101-017 WAS D6102-017, ZN A6-1; ADD NOTE ZN C4-2; ADD R0.031 ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165 ZN B7-1; ADD 0.615 ZN C5-1; ADD 0.648 ZN C4-1; ADD 0.250 ZN D6-2; ADD 0.060 ZN C2-2; 0.73 WAS 0.85 ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	08.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS	INBOARD SADDLE	
DATE	15.02.11	REV. PC1 SHEET 1 OF 4 SCALE NTS	

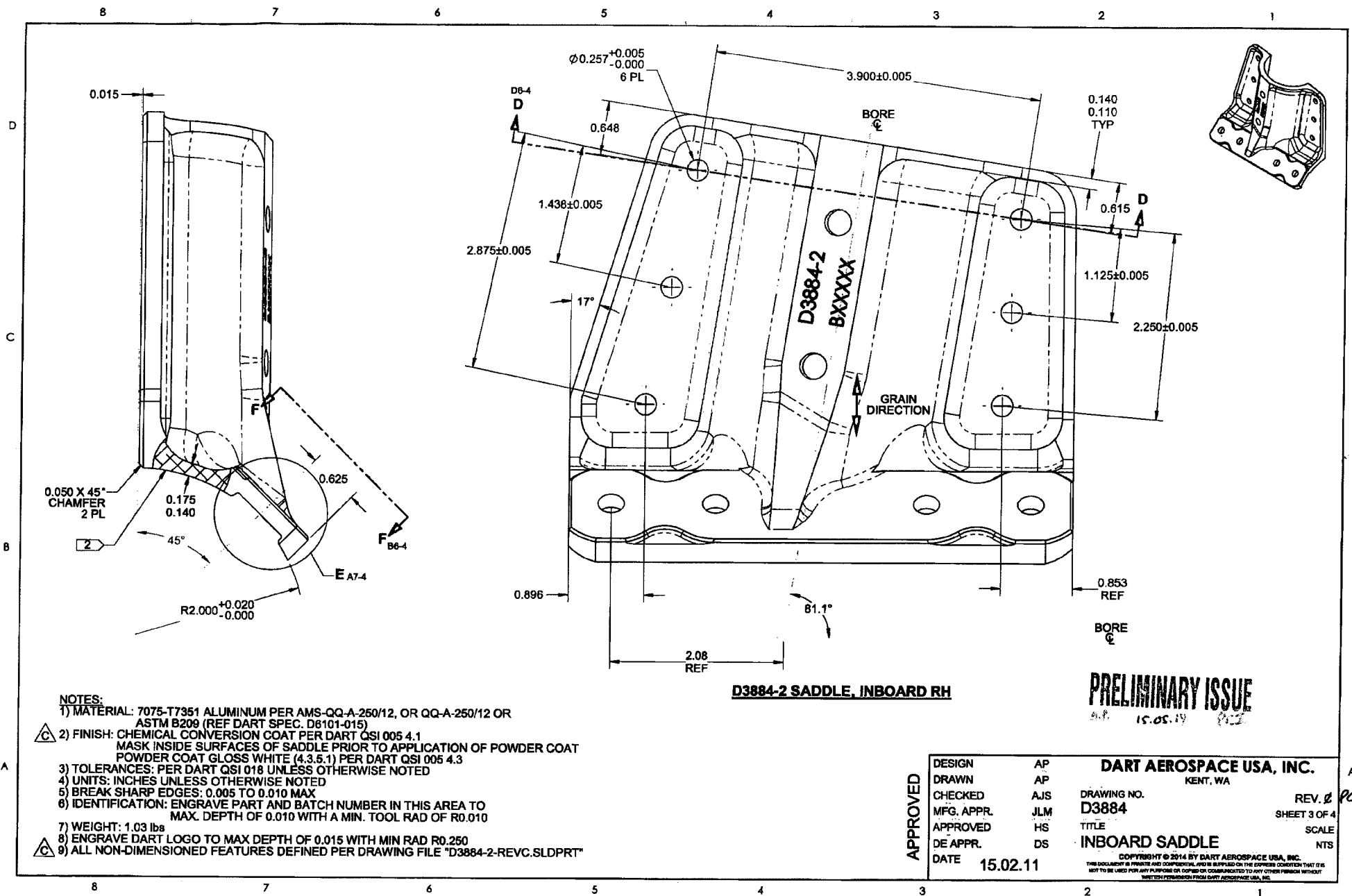
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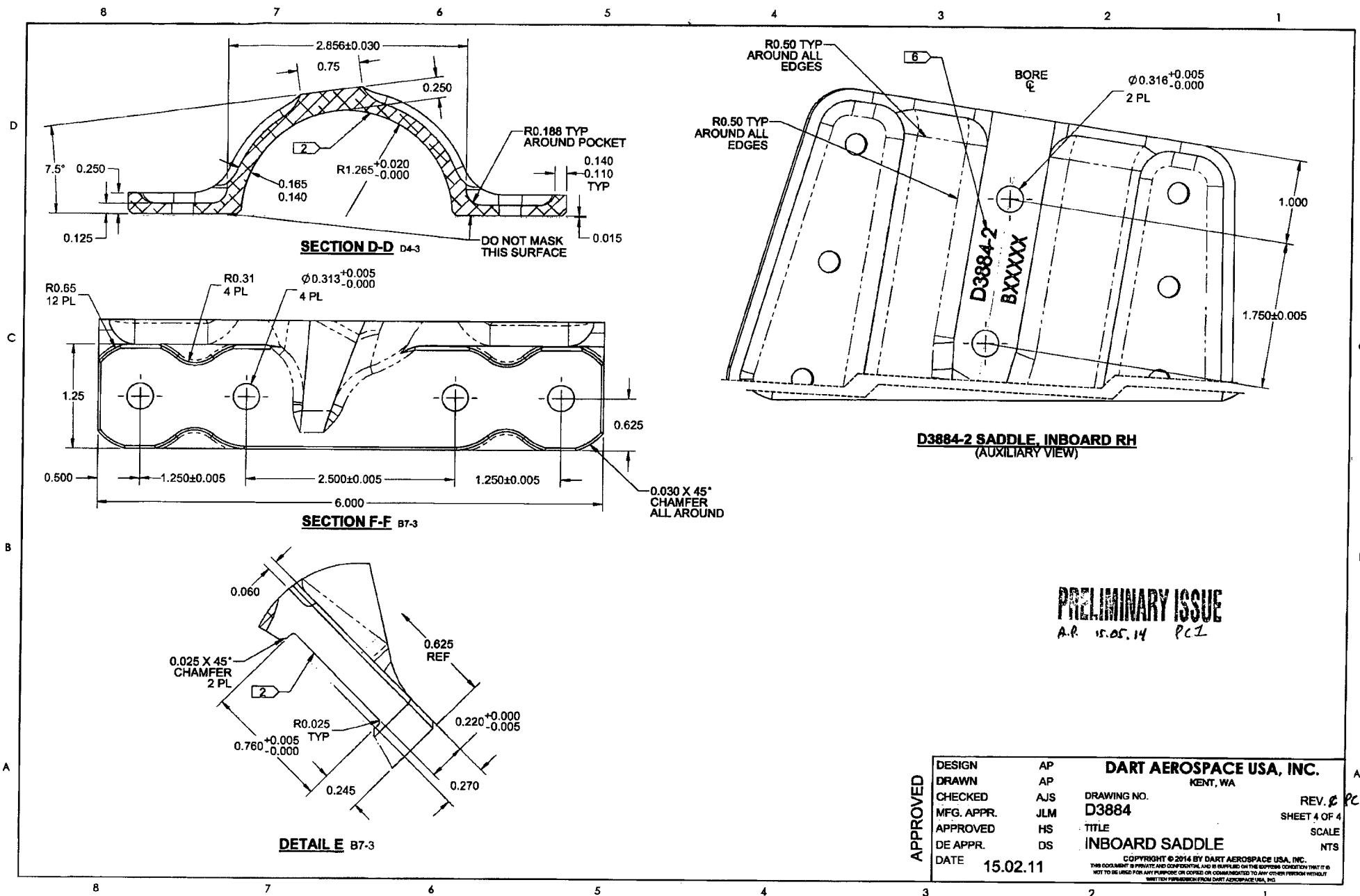


D3884-1 SADDLE, INBOARD LH
(AUXILIARY VIEW)

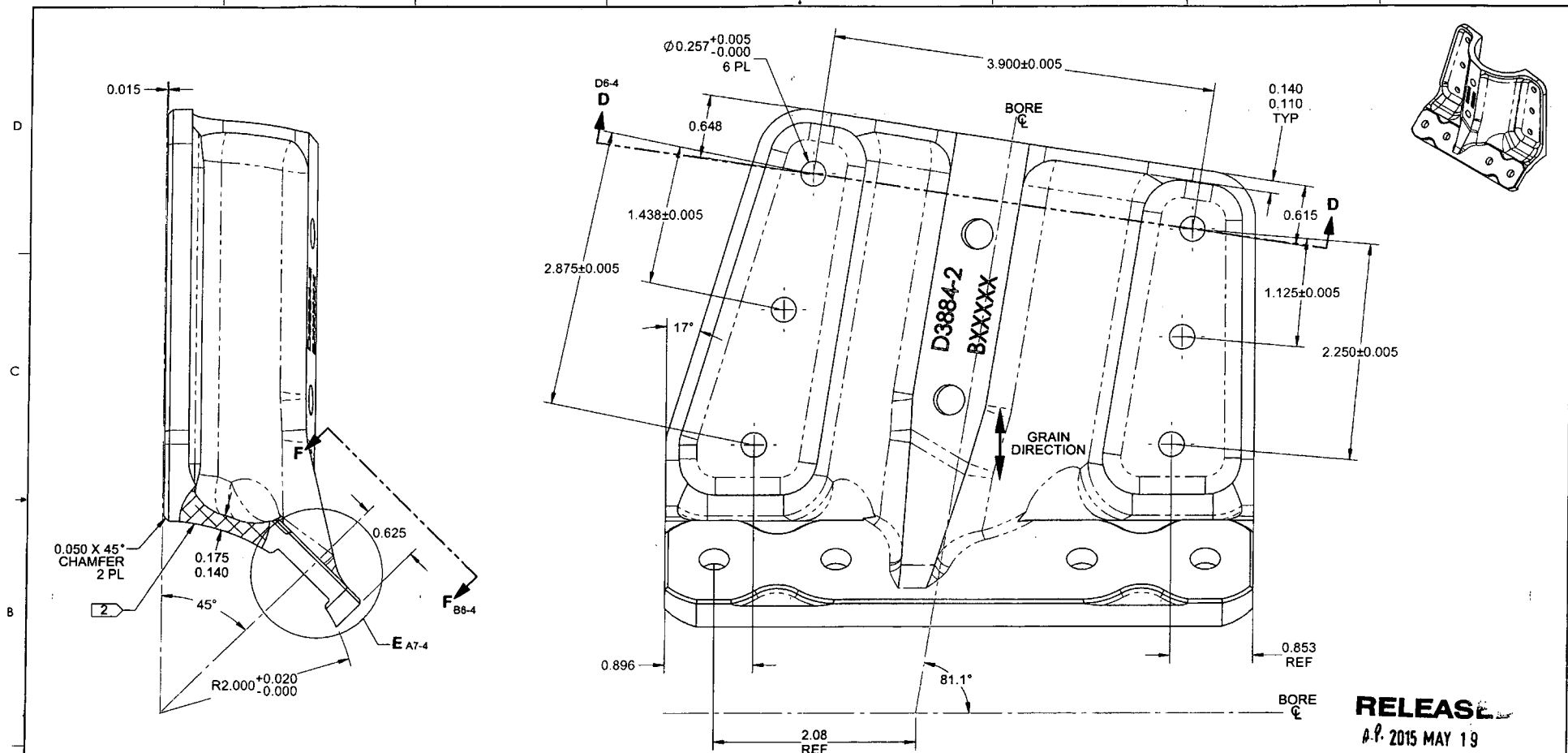
PRELIMINARY ISSUE
A.R. 15-05-14
PC1

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA		REV. <i>PC1</i>
	DRAWN	AP			
	CHECKED	AJS	DRAWING NO.	D3884	SHEET 2 OF 4
	MFG. APPR.	JLM	TITLE	INBOARD SADDLE	SCALE
	APPROVED	HS	DATE	15.02.11	NTS
	DE APPR.	DS	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		





8 7 6 5 4 3 2 1



NOTES:

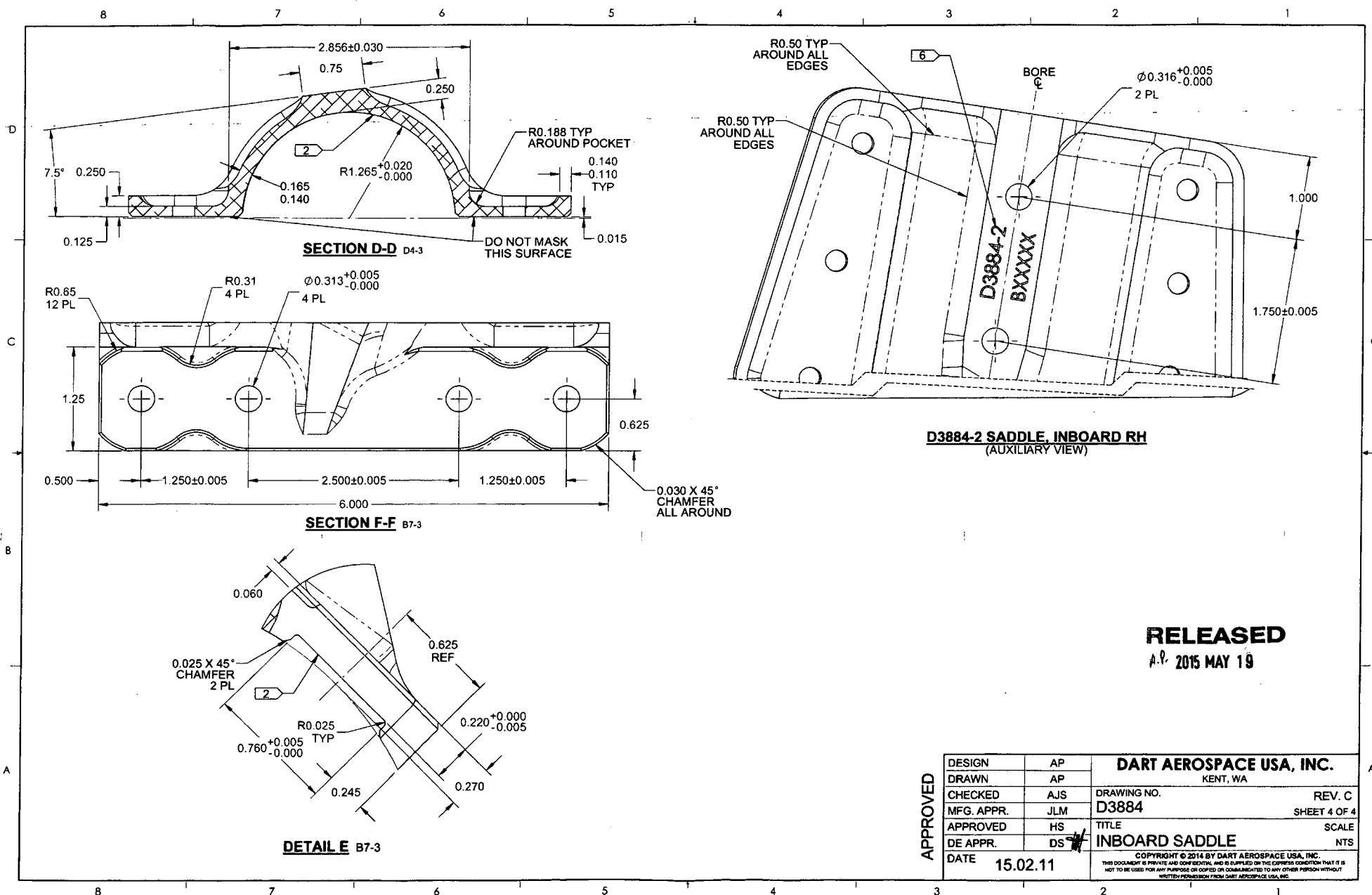
- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-2-REVC.SLDPRT"

D3884-2 SADDLE, INBOARD RH

RELEASE
A.P. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
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	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
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8 7 6 5 4 3 2 1



RELEASED

A.P. 2015 MAY 19

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	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D3884	SHEET 4 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	INBOARD SADDLE	NTS
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